

Work Order ID 75508

75508

Eagle

Page 1

October-24-11 11:49:29 AM

Item ID: D4165-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 24/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 27/10/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/24 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4165	B

100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<u>2024.040</u>	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B16-10-25

B11-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
135 *135* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

8 ulu/25

1 BR 11-10-25

IXPm 11/10/25

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October-24-11 11:49:29 AM

Page 3

Reference:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

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Picklist Print

October-24-11 11:49:34 AM

Page 1

Work Order ID: 75508

75508

Parent Item: D4165-1

D4165-1

Parent Item Name: Doubler

Start Date: 24/10/2011

Required Date: 27/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	110.5184	0.353	0.371579			

M2024T3S 040

2024-T3 .040 sheet

**

B11-10-25

Location

Loc Qty

Loc Code

MAT022

110.518421

113162

1.1

117684

109.418421

117684

①

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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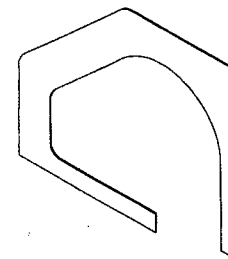
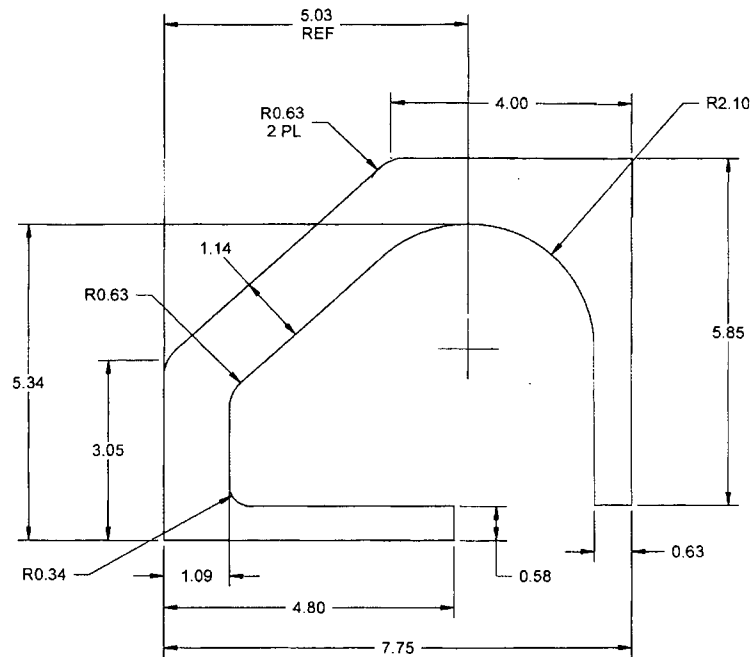
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STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 75508 M.L.J

11/10/24

RELEASED
R 2011-04-15

D4165-1 DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

B	CORRECTED BEND ORIENTATION ON D4165-9 (ZN C1-5)	RF	11.04.11
A	NEW ISSUE	RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4165
REV. B
SHEET 1 OF 7
TITLE VRD PARTS
SCALE NTS

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